

Work Order ID 139909

139909

Page 2

Monday, December 14, 2015 12:50:21 PM

Item ID: D5101-047 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crossbolt Spacer Assembly
Start Date: 12/14/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 12/18/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									DAS
QC	Memo	0.00				10	0		08
Quality Control									9-89
130	QC8- Inspect parts - second check	0.00							
130									DAS
QC	Memo	0.00				10	0		14
Quality Control									9-89
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00				10	FF		JAN 21 2016
Small Fab	INSTALL HELICOIL AS PER DWG.								

Work Order ID 139909***139909***

Page 3

Monday, December 14, 2015 12:50:21 PM

Item ID: D5101-047

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer Assembly

Start Date: 12/14/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170									
QC	Memo	0.00							JAN 2 1 2016
Quality Control									
180	Identify as per dwg & Stock Location: <u>52</u>	0.00							DAS 6 9-89
180									
Packaging	Memo	0.00							JAN 2 1 2016
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							JAN 2 2 2016
Quality Control									

MCS JAN 2 1 2016

Picklist Print

Monday, December 14, 2015 12:50:26 PM

Page 1

Work Order ID: 139909

139909

Parent Item: D5101-047

D5101-047

Parent Item Name: Crossbolt Spacer Assembly

Start Date: 12/14/2015

Required Date: 12/18/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev.A New issue JFS 15/09/29 Verified by: DD
15.12.10 AS PER DWG REV B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F7-10

Purchased

No

Each

50.0000

40

MS21209F7-10

Heli-Coil, Locking

FF JAN 21 2016

Location

Loc Qty

Loc Code

GA

133932

50

m133694

50

24
16

MDEL RINB1.000X04.0
00

Purchased

No

100

f

21.7000

0.184

1.936842

MDEI RINB1 000X04 000

Delrin Bar

b.a 16/01/05

Location

Loc Qty

Loc Code

MAT011

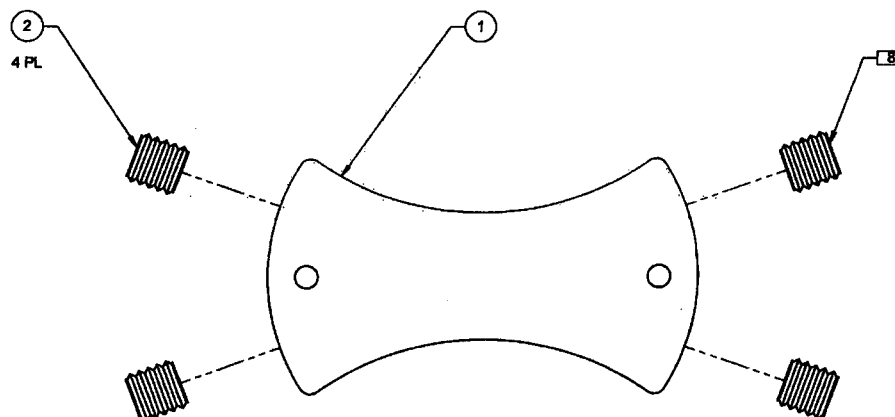
21.7

→ m133488

21.7

1.875

ITEM	QTY	P/N	DESCRIPTION
	X	D5101-041	CROSSBOLT SPACER ASSY
1	1	D5101-1	CROSSBOLT SPACER
2	4	MS21209F7-10	HELICOIL, LOCKING



D5101-041 CROSSBOLT SPACER ASSY

NOTES:

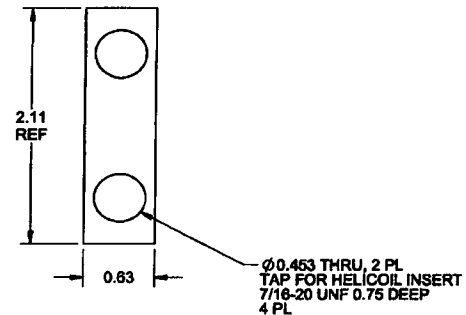
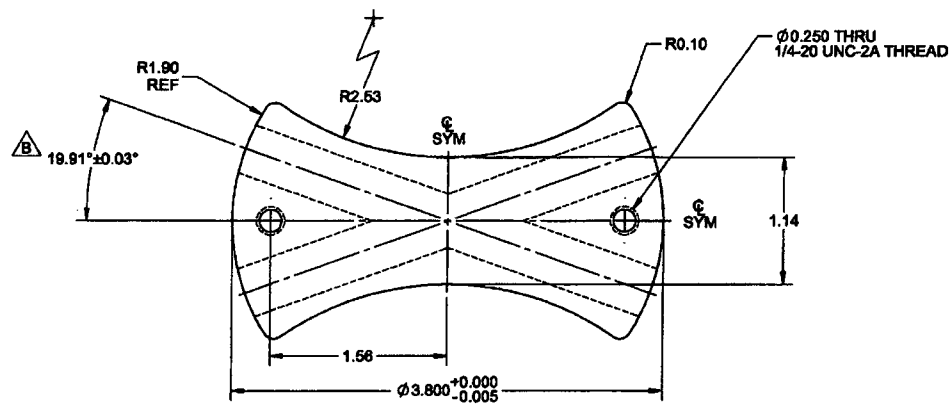
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.7
- 7) WEIGHT: 0.14 lbs
- 8) INSTALL MS21209F7-10 HELICOIL ONE FULL REVOLUTION BELOW SURFACE

Handwritten: 15-12-14
139909

RELEASED
2015-12-09
ECN 15-651

B	REVISE NOTE 8 (SH 1, 3 & 4) & NOTE 8 (SH 1), REVISED HELICOIL ANGLE TO 16.91° WAS 16°. ADD D5101-7-047 (SH 646), REMOVE 0.008 HOLES FROM -1, MS21209F7-10 WAS MS21209F7-16.	DB	15.10.15
A	NEW ISSUE	AK	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC.	
DRAWN	AP	EUGENE, OR	
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5101	SHEET 1 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	15.10.15	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE OFFICIAL RECORD THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



D5101-1 CROSSBOLT SPACER

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

RELEASED
2015-12-09

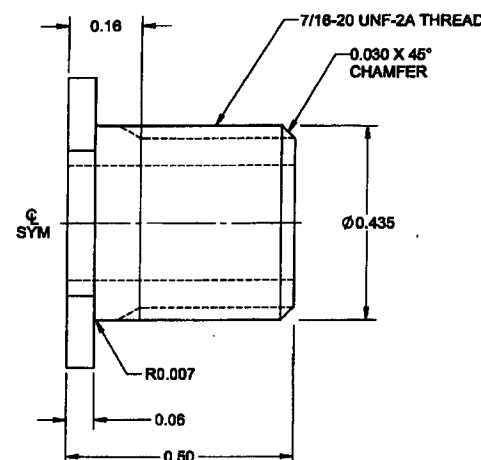
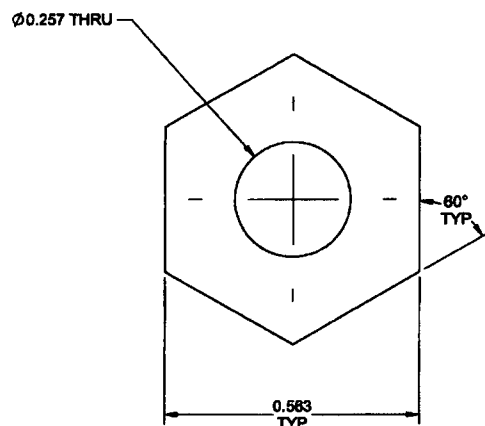
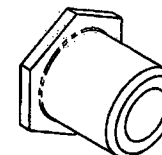
APPROVED

DESIGN	AK
DRAWN	AP
CHECKED	DB
MFG. APPR.	JLM
APPROVED	WM
DE APPR.	DS
DATE	15.10.15

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D5101** REV. B
SHEET 2 OF 6
TITLE **CROSSBOLT SPACER** SCALE NTS

COPYRIGHT © 2014 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PREPARED AND COMPILED, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DESIGN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D5101-3 INSERT

NOTES:

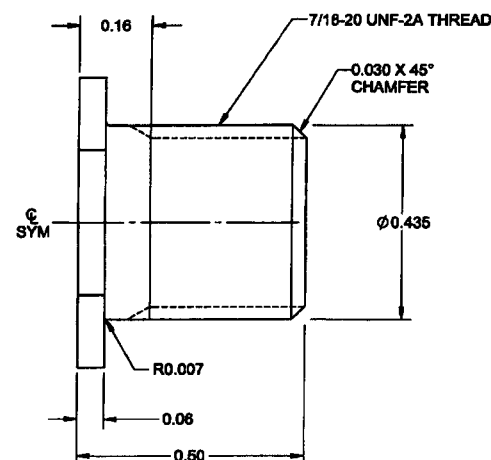
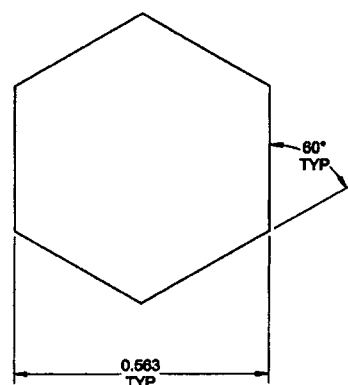
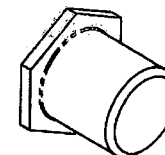
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8
(OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M0061 T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.005 lbs



RELEASED
2015-12-09

APPROVED

DESIGN	AK	DART AEROSPACE USA, INC.	
DRAWN	AP	EUGENE, OR	
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5101	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	15.10.15	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5101-5 INSERT

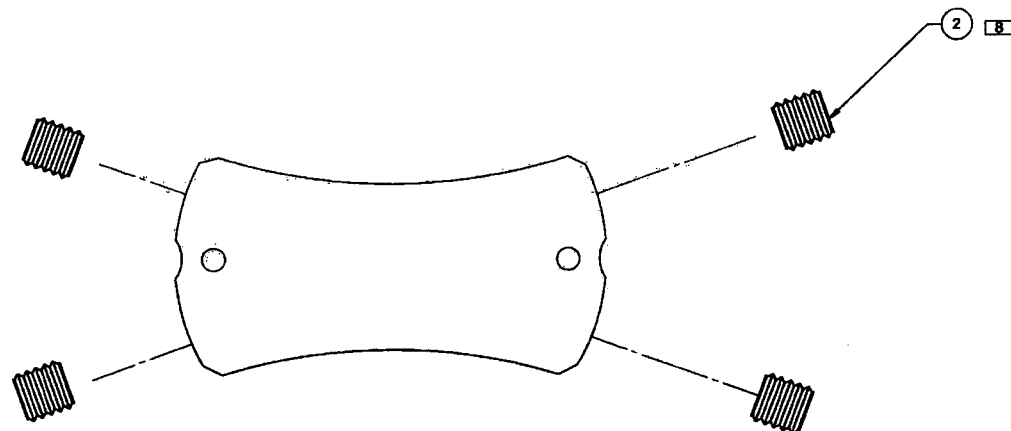
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8
(OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.008 lbs

RELEASED
2015-12-09
APPROVED

DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5101	SHEET 4 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	15.10.15	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D5101-047	CROSSBOLT SPACER ASSY
1	1	D5101-7	CROSSBOLT SPACER
2	4	MS21209F7-10	HELICOIL, LOCKING



△ D5101-047 CROSSBOLT SPACER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.16 lbs
- 8) INSTALL MS21209F7-10 HELICOIL ONE FULL REVOLUTION BELOW ADJACENT SURFACE

RELEASE
2015-12-09
APPROVED

DESIGN	AK	DART AEROSPACE USA, INC.	
DRAWN	AP	EUGENE, OR	
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5101	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	15.10.15	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

